

Date: Tuesday, 10/2/2007 1:45:45 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	1/4 TURN FASTNER RAIL (BLACK)
Job Number	34968	Part Number	D103858B
Estimate Number	10096	Drawing Number	D1038
P.O. Number	N/A	Project Number	N/A
This Issue	10/2/2007	S.O. No.	N/A
Prsht Rev.	NC	Type	MACHINED PARTS
First Issue	N/A	Drawing Revision	B
Previous Run	34944	Material	N/A
Written By		Due Date	11/5/2007
Checked & Approved By	10-10-02	Qty:	60
Comment	Est: E 03.05.02 Reformat; Added label KJ/RF Est Rev:F 06-08-16 Updated Packaging Procedures JLM	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	DC	DOCUMENT CONTROL  
		Comment: DOCUMENT CONTROL Create white labels and bag them  
2.0	D2023	Extrusion, Fastener Rail  
		Comment: Qty.: 1.9030 f(s)/Unit Total : 95.1500 f(s) Extrusion, Fastener Rail  
3.0	BAND SAW	BAND SAW  
		Comment: BAND SAW Cut extrusion D2023 to length 21.81" (+0.06/-0.00)  
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1  
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio and Dwg D1038-58  
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE  
6.0	QC8	SECOND CHECK  
		Comment: SECOND CHECK  

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

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Seq. #: Machine Or Operation:

Description :

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

INSPECT WORK TO CURRENT STEP

*10/12/07 (60) caned*

8.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

*10/12/07 (X60)*

9.0 OUTSIDE SERV.30 OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 5290

Black Anodize as per Dwg D1038

*10/12/07 (60)*

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

*10/12/07 (60)*

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

*10/12/07 (X60)*

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: M104298

*P10  
X59*

2-Grind wire flush and deburr

3-Clean

*M108/01/08*

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*10/12/08 (X58)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-01-08	12.0	1 part found to be warped, and does not fit into the jig.	QS1012	Scrap & destroy, no replace.	ML 08/01/08	08-01-08	QS1012	08-01-08

NOTE: Date & initial all entries

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Part Number: D103858B

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: 3 FG 14

AS 08/01/09

569

60

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doa/01/11

Job Completion



U 08/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34968
Description: 1/4" Turn Fastener	Part Number:	D1038-58B
Inspection Dwg: D1038-58B Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

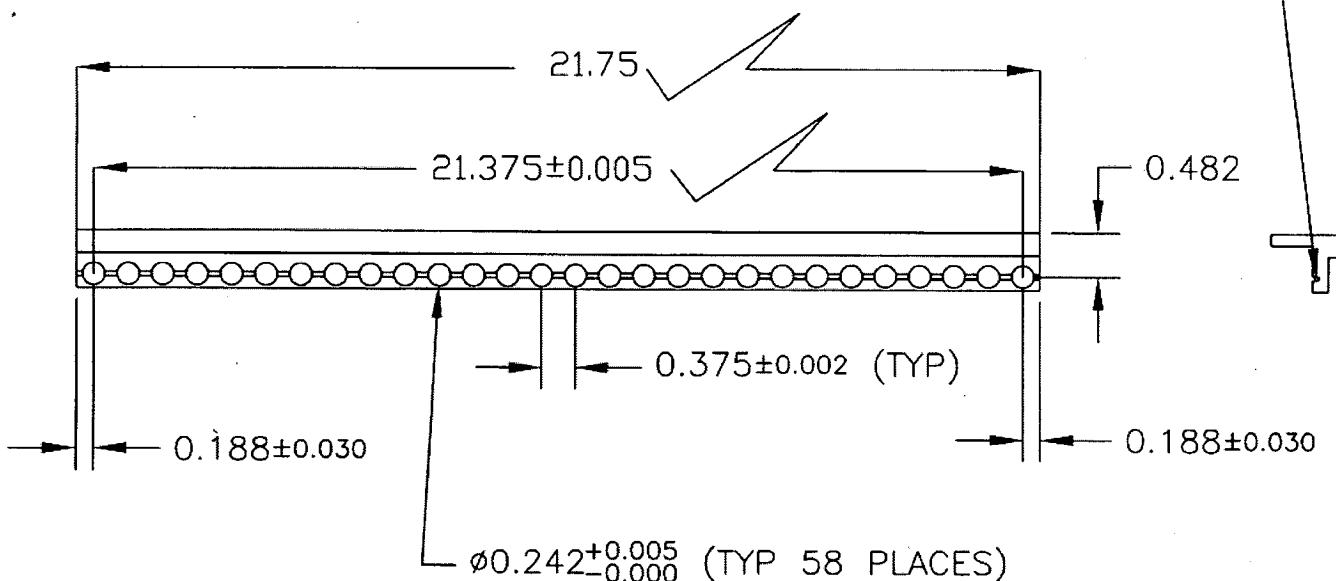
Measured by:	J.L	Audited by:	SF	Prototype Approval:	N/A
Date:	07/12/12	Date:	07/12/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.16	New Issue	KJ/JLM	
B	06.03.08	21.750 was 12.750, Dwg rev. changed	KJ/JLM	

**DART****RELEASED**  
05.03.31

DESIGN	DRAWN BY	DART AEROSPACE LTD		
<i>CH</i>	<i>ASL</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
<i>CH</i>	<i>CH</i>	D1038	SHEET 1 OF 1	
DATE	TITLE			
05.02.02	1/4 TURN FASTENER RAIL			
A		04.05.14	UPDATE TOLERANCE	
B		05.02.02	REDRAWN, UPDATE NOTES	

STAKE  $\varnothing 0.50$  TYPE 302 STAINLESS  
STEEL WIRE FULL LENGTH  
(REF DART SPEC M302SW.050)



D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE  
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES  
ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
3) UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34968



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2  
 Telephone: (514) 429-7777 Fax: (514) 429-5108  
 Certifié ISO 9001-2000 / AS9100 certified  
 approuvé NADCAP approved

61066

21-Dec-2007

## CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET  
 HAWKESBURY, ONTARIO  
 K6A 1K7

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/  
NO. DE COMMANDE: 00005290

S222



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	50	50	D103858B B34944	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	60	60	D103859B B34968	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	15	15	D32993 B35139	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
4	13	13	D32991 B35138	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager